

Work Order ID 151575

27/04
151575

Page 1

Thursday, September 29, 2016 9:19:28 AM

Item ID: 646.4002 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AS350 Wiper Deflector
 Start Date: 9/23/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS Date: SEP 29 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.4000	C1	DAS 6 9-89	SEP 30 2016						
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 646.4002								
						DAS 27 9-89			OCT 01 2016
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
						DAS 6 9-89			OCT 03 2016
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control						DAS 27 9-89			

OCT 04 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 151575***151575***

Page 2

Thursday, September 29, 2016 9:19:28 AM

Item ID: 646.4002

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350 Wiper Deflector

Start Date: 9/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/6/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP 646.4002
Location : FG102DAS
27
9-89DAS
28
9-89

OCT 04 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

DAS
21
9-89

OCT 05 2016

VS 10/10/05

DAS
21
9-89

OCT 05 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 			
Description Work Order Deviation				Disposition							
								Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Thursday, September 29, 2016 9:19:31 AM

151575

646 4002

Required Qty: 1.00

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3410 *646.3410* LH Wiper Deflector		Manufactured	No				Each	26.0000		1		OCT 03 2016	DAS 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck010				26					
					125083			14					
					<u>97822</u>			12					
646.3411 *646.3411* RH Wiper Deflector		Manufactured	No				Each	24.0000		1		OCT 03 2016	DAS 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck010				24					
					125083			10					
					<u>97823</u>			14					
NAS1149F0332P *NAS1149F0332P* Washer		Purchased	No				Each	1,782.000		16		OCT 03 2016	DAS 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				282					
					m133709			282					
				ST262				1500					
					<u>m135544</u>			1500					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Thursday, September 29, 2016 9:19:31 AM

Page 2

Work Order ID: 151575

151575

Parent Item: 646.4002

646 4002

Parent Item Name: AS350 Wiper Deflector

Start Date: 9/23/2016

Required Date: 10/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,113.000

6

OCT 03 2016

DAS
6
9-89

DAS
28
9-89

MS21042L3

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

253

m134360

112

m135135

141

OVER007

1200

m135530

600

m135767

600

ST303

653

m135407

110

m135600

543

6

MS27039-1-19

Purchased

No

Each

249.0000

2

OCT 03 2016

DAS
6
9-89

DAS
28
9-89

MS27039-1-19

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

82

m134134

82

ST280

167

m135774

167

2

Thursday, September 29, 2016 9:19:31 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Thursday, September 29, 2016 9:19:31 AM

Work Order ID: 151575

151575

Parent Item: 646.4002

646 4002

Parent Item Name: AS350 Wiper Deflector

Start Date: 9/23/2016

Required Date: 10/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-18

Purchased

No

Each

1,747.000

2

DAS 6 9-89

DAS 28 9-89

MS27039-1-18

Screw

**

OCT 03 2016

Location

Loc Qty

Loc Code

GA

245

123522

51

124326

194

over006

1171

124326

1171

ST280

331

124326

331

DAS 27 9-89

646.3814

Manufactured

No

Each

16.0000

2

OCT 03 2016

DAS 6 9-89

DAS 28 9-89

646 3814

Wiper Bracket

**

Location

Loc Qty

Loc Code

CCK106

16

125083

16

600.1012

Purchased

No

Each

15.0000

1

OCT 03 2016

DAS 6 9-89

DAS 28 9-89

600 1012

Sealant PR1425B2 (#654 sem)

**

Location

Loc Qty

Loc Code

cck017

15

m135407

1

m135530

8

m135600

6

DAS 27 9-89

05/01/2017

MS24694-S53

Purchased

No

Each

278.0000

2

OCT 03 2016

DAS 6 9-89

DAS 28 9-89

MS24694-S53

SCREW

**

Location

Loc Qty

Loc Code

ST284

278

113359

278

DAS 27 9-89

Thursday, September 29, 2016 9:19:31 AM

Shop Packet Print

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05304

SHEET 1 OF 1

DWG NO. 646.4000

REV: C

PREPARED BY J. BECKER

DATE: 02/04/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: AS350 CABLE CUTTERS KIT

APPROVED BY: ENGR. *[Signature]*

MFG *[Signature]*

QC *[Signature]*

EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED F/N 12.

ECR: N/A

ACTION ITEM:
1. N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *1515 H* *MS*
16-09-29

SHEET 1, BOM IS:

12	R	601.1624	8	16	LOCKNUT	MS21042L3	
F/N	TC	PART NUMBER	4006	4005	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM					☐ MAJOR ☒ MINOR	☐ YES ☒ NO	



Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval _____		
Description Work Order Deviation				Disposition					
Handwritten notes in red ink: 1. 10/10/10 2. 10/10/10 3. 10/10/10 4. 10/10/10 5. 10/10/10 6. 10/10/10 7. 10/10/10 8. 10/10/10 9. 10/10/10 10. 10/10/10								Completed By _____	
								Lead hand / Supervisor Approval Verification _____	
								QC / QA Coordinator Approval _____	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	MS27039-1-10	
1	1	1	77	646.9410	SHIM	AN3-17A	
	4	4	76	601.2764	WASHER	MS27039-1-10	
	2	2	75	601.2973	LOCKNUT	MS27039-1-10	
	2	2	74	601.2988	SCREW	MS27039-1-10	
	2	2	73	601.2943	LOCKNUT	MS27039-1-10	
	2	2	72	601.3128	NUT	AN3-17A	
	2	2	71	601.3209	LOCKNUT	MS27039-1-10	
	4	4	70	601.2638	WASHER	MS27039-1-10	
	2	2	69	601.2669	BOLT	AN3-17A	
	2	2	68	601.3119	CLEVIS	AN3-17A	
	2	2	67	601.3121	EYE BOLT	AN3-17A	
	2	2	66	650.9201	EYE BRACKET ASSY		
REF	REF	REF	65	647.5701	GPS MOUNT KIT		
		2	64	601.3151	WASHER	MS27039-1-10	
		2	63	601.2911	SCREW	MS27039-1-10	
	24	24	62	601.2637	SCREW	MS27039-1-10	
2	2	2	61	601.2763	BOLT	AN3-17A	
	1	1	60	646.3913	SHIM		
	4	4	59	646.3912	SHIM		
	1	1	58	646.3911	SHIM		
	4	4	57	646.3910	SHIM		
	5	5	56	600.1013	PRIMER		
	B FT	B FT	55	600.0129	VHB TAPE		
	1	1	54	600.1012	SEALANT	MS27039-1-10	
	1	1	53	600.0991	MAGNABOND 6398 PART B		
	1	1	52	600.0990	MAGNABOND 6398 PART A		
6	10	10	51	601.2826	BOLT	AN3-17A	
		2	50	646.3814	WIPER BRACKET		
		2	49	601.2910	SCREW	MS27039-1-10	
	2	2	48	601.1365	SCREW	MS27039-1-10	
	2	2	47	646.3719	DOUBLER		
	2	2	46	646.3718	CUSTOM WASHER		
	1	1	45	646.3717	DOUBLER		
	22	22	44	601.1948	SCREW	MS27039-1-10	
	2	2	43	601.1952	SCREW	MS27039-1-10	
	4	4	42	601.1956	SCREW	MS27039-1-10	
4006	4005	4004	4003	4002	4001	FIND #	PART #
							DESCRIPTION
							MATL
							SPEC.

REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 05304, 05305 & 05306	02/08/2018	P. BRAVO
B	INCORPORATED ECN 05304, 05305 & 05306	11/04/2018	P. BRAVO
C	INCORPORATED ECN 05304	09/07/2018	P. BRAVO

		2	2	41	601.2829	SCREW	MS27039-1-10
		2	2	40	601.2831	RIVET	MS27039-1-10
		1	1	39	646.3716	GAUGE BRACKET	
		6	6	38	601.1953	SCREW	MS27039-1-10
		2	2	37	646.3715	STRUT DOUBLER	
	2	2	2	36	601.2824	BOLT	AN3-17A
12	36		36	35	601.2277	RIVET	MS27039-1-10
6	18		18	34	600.0795	NUTPLATE	MS27039-1-10
3	3		3	33	601.2565	RIVET	MS27039-1-10
1	1		1	32	646.3813	STRUT BRACKET	
4	4		4	31	601.2822	BOLT	AN3-17A
2	2		2	30	646.3812	GUSSET BRACKET	
8	8		8	29	601.2564	RIVET	MS27039-1-10
1	1		1	28	646.3714	GUSSET	
	1	1	1	27	646.3610	FILLER	
	3	3	3	26	601.2830	SCREW	MS27039-1-10
	2	2	2	25	601.2825	BOLT	AN3-17A
	1	1	1	24	646.3811	RADIUS BLOCK	
	1	1	1	23	646.3712	CLIP	
	1	1	1	22	646.3711	CLIP	
8	8		8	21	601.2832	RIVET	MS27039-1-10
14	14		14	20	601.2020	RIVET	MS27039-1-10
4	6	6	10	19	601.2823	BOLT	AN3-17A
1	1		1	18	601.2827	BOLT	AN3-17A
5	5		5	17	601.2912	SCREW	MS27039-1-10
1	1		1	16	646.3713	GUSSET	
1	1		1	15	646.3210	SUPPORT	
	1		1	14	646.3710	DOUBLER	
1	1		1	13	646.3110	CHANNEL	
14	10	8	53	6	61	12	601.1624
16	32	18	120	16	144	11	601.1607
						10	646.3410
						9	646.3411
						8	647.7703
						7	647.7702
						6	646.3511
						5	646.3510
2	2		2	4	646.3810	BRACKET	
						3	646.2910
						2	646.3001
						1	646.3301
							646.3301
X							646.4006
							646.4005
							646.4004
							646.4003
							646.4002
							646.4001
4006	4005	4004	4003	4002	4001	FIND #	PART #
							DESCRIPTION
							MATL
							SPEC.

QTY NEXT ASSY (S)		DATE APPROVED DESIGNED BY APPROVED BY DATE		3030 ENTERPRISE CT. VISTA, CA 92081 (760)-724-5300	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES 2 PLACES DECIMALS 80'S 3 PLACES DECIMALS 100'S 4 PLACES DECIMALS 100'S		SCALE NONE SHEET 1 OF 5		AS350 CABLE CUTTERS KIT 07/2016 646.4000	

DQA: _____ Date: _____



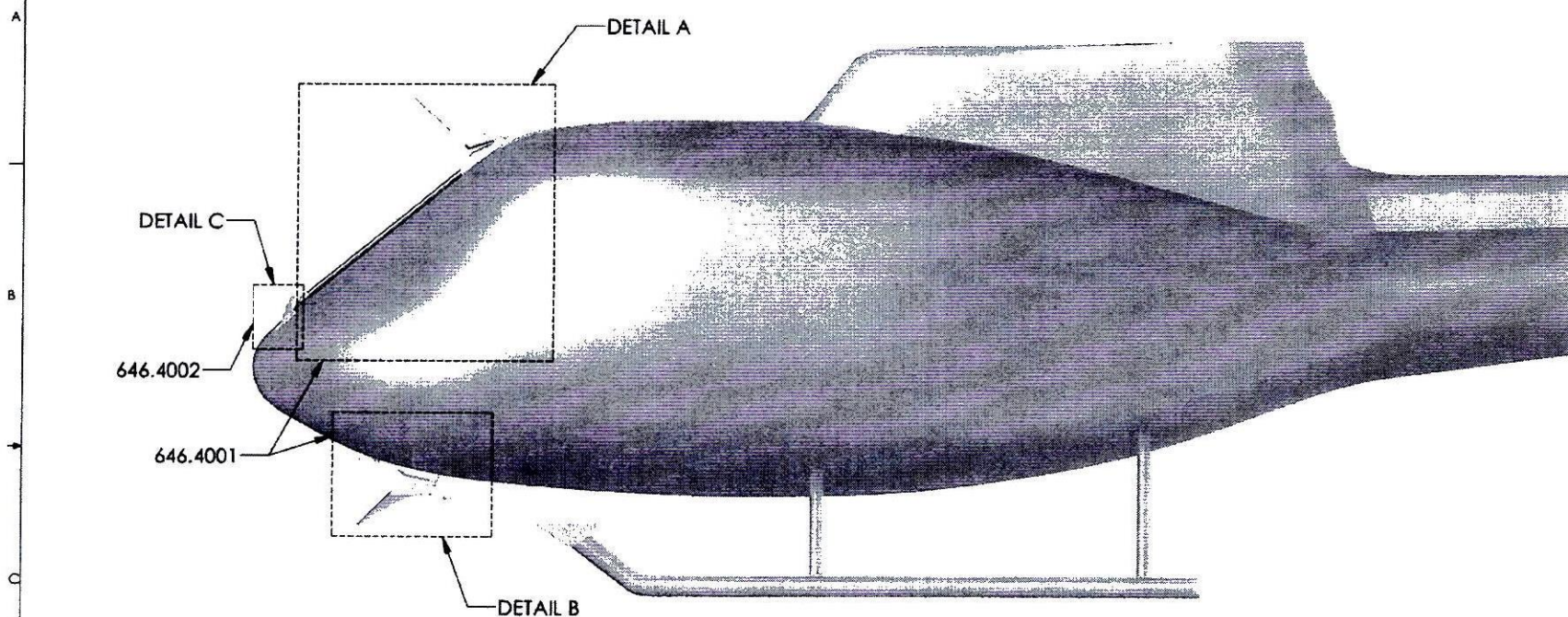
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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ORIGINAL DATE 08/24/08		DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300	
DRAWN BY E. HUNT		P. BRAYO	
DRAWING APPROVAL P. BRAYO		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		AS350 CABLE CUTTERS KIT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±0.0 3 PLACE DECIMALS ±0.005 ANGLES ± 5°	REV B	DATE CODE 07M06	DATE NO. 646.4000
SCALE: NONE		SHEET 2 OF 5	

DQA: _____ Date: _____



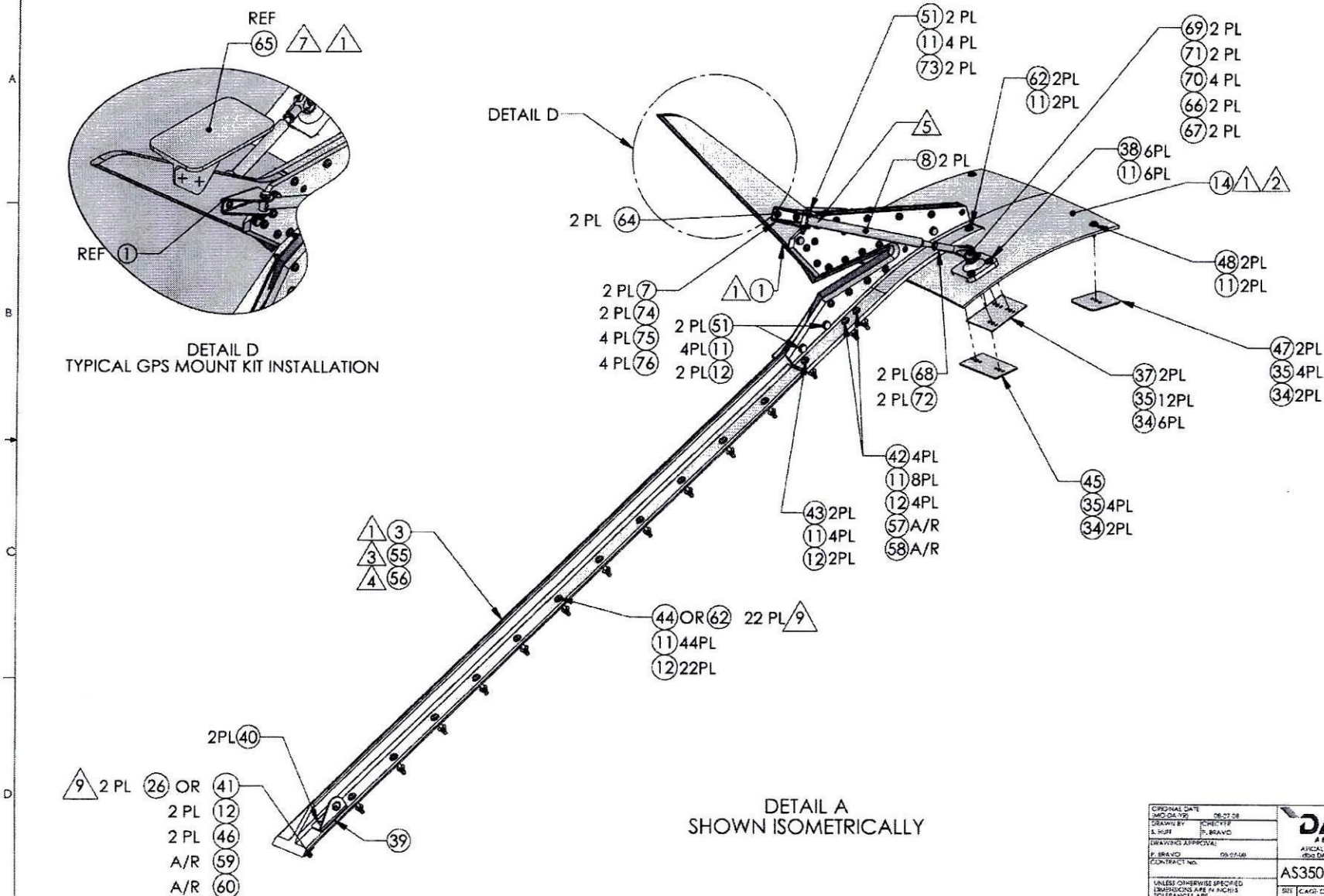
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

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ORIGINAL DATE: 06-27-08		3030 ENTERPRISE CT., SUITE A, VISTA, CA 92081 (760)-724-5300	
DRAWN BY: J. HUNT	DESIGNED BY: P. BRAVO	AFICAL INDUSTRIES, INC. (760)-724-5300	
DRAWING APPROVAL: P. BRAVO	DATE: 06-27-08	AS350 CABLE CUTTERS KIT	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS ±.01, 3 PLACE DECIMALS ±.005, ANGLES ±.5°		SHEET: 646.4000	REV: C
SCALE: NONE		SHEET: 3 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

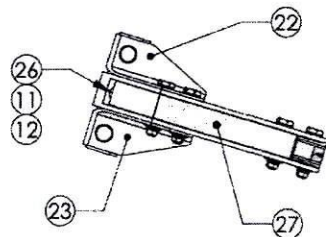
QA Closed: _____ Date: _____

Work Order update only ☐

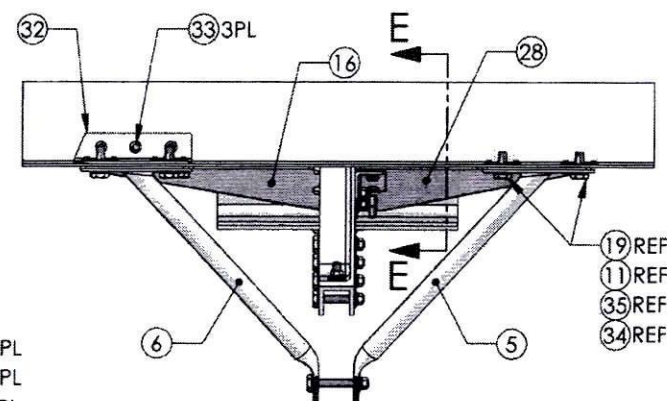
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DETAIL B
LH SIDE SHOWN WITH AIRFRAME

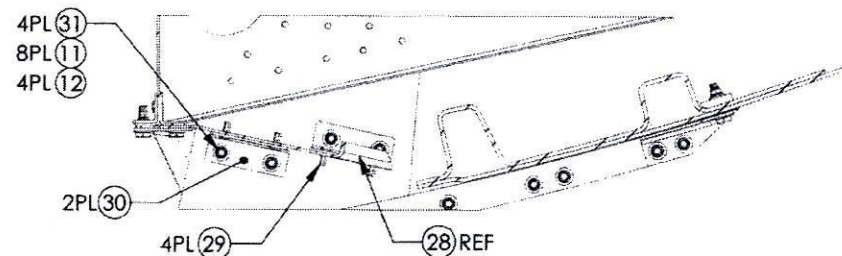
DETAIL B
LH SIDE SHOWN WITH AIRFRAME



SECTION C-C



SECTION D-D
CUTTER HIDDEN FOR CLARITY



SECTION E-E

ORIGINAL DATE MAY 24 1991 05:2708	 DART AEROSPACE ARCADE INDUSTRIES INC. 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 774-5300	3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 774-5300
FORWARDED BY S. KREI P. BEAVER		
DRAWING APPROVAL (BY) DATE		
CONTRACT NO.		
AS350 CABLE CUTTERS KIT		
NUMBER OF PARTS SHIPPED DIMENSIONS ARE IN INCHES 2 DIMENSIONS 2 PIECE DIMENSIONS 8.710 3 PIECE DIMENSIONS 8.710 ANGLE 1 8°	KIT / CASE CODE 07A2A2	DWG. NO. 646.4000
	SCALE NONE	REV C SHEET 4 OF 5

DQA: _____ Date: _____



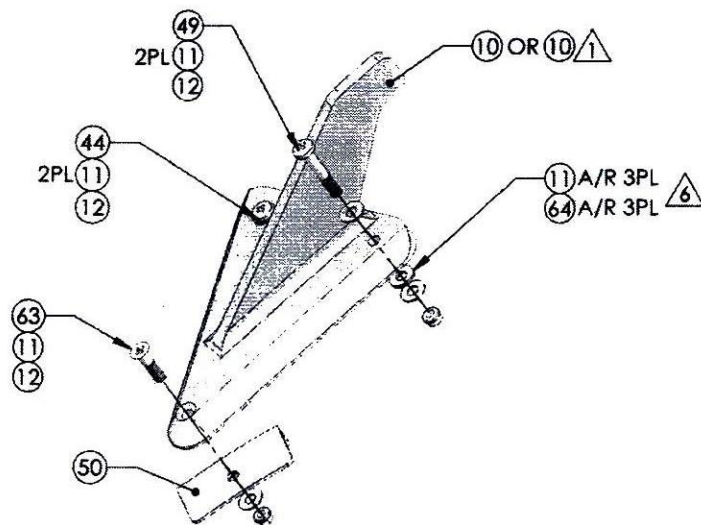
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

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WRITTEN PERMISSION OF APICAL INDUSTRIES DART AEROSPACE IS PROHIBITED.



DETAIL C
LH SHOWN EXPLODED
RH OPPOSITE

ORIGINAL DATE 08-27-08		DART 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY: C. PECEP T. HAH P. BRAVO		APICAL INDUSTRIES, INC. DART AEROSPACE	
DESIGNED BY: APPROVAL P. BRAVO 08-07-08		AS350 CABLE CUTTERS KIT	
CONTRACT NO.		SIZE: CASH COPY B 07/03/08	REV: C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES .5°		DWG. NO: 646.4000	SCALE: NONE
		SHEET 5 OF 5	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 151575

151575

Page 1

Thursday, September 29, 2016 9:19:28 AM

Item ID: 646.4002 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AS350 Wiper Deflector
 Start Date: 9/23/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS Date: **SEP 29 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	DAS							
646.4000	C1	6							
		9-89							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 646.4002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

OCT 03 2016

NOTES:

- A

05304

D

4

QTY		ORIGIN: DATE	INSTR: TYPE	UNIT	PRICE	DESCRIPTION	MATL	SPEC.
NEXT ASSY (S)		ORIGIN: DATE INSTR: TYPE UNIT PRICE DESCRIPTION: APPROVAL P. REVISED COMMENTS: NO.				DART 3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (619) 724-3300 AEROSPACE APCAL FORMERLY, INC. (also DART AEROSPACE)		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. HOLE DIMS: $\pm .015$ 2. PLACE DIMS: $\pm .015$ 3. HOLE DIMS: $\pm .005$ 4. HOLE DIMS: $\pm .005$						ASS350 CASE CUTTERS KIT		
SEE B						SEE CASE CODE B 073M36 SCALE NONE		
CWS. NO. 646,400						SHIP 1 OF 5		

ORIGINAL DATE 11/01/87 12:32 PM RECEIVED BY S. EHRF P. MAYO DRAWING APPROVAL P. MAYO 11/01/87 CONTRACT NO.		DART AEROSPACE APICAL INDUSTRIES, INC. 3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760) 724-5300	
AS350 CABLE CUTTERS KIT			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 10 BRANCHED AREA 2 PLACE CUTTERS 1000 1 PLACE DISCONNECT 3.000 ANGLE 2		SEE B	SHEET 07/16/86 646,40000 SCALE NONE CHECKED BY C